

Work Order ID 152117

Wednesday, October 19, 2016 3:29:11 PM

152117

TULMAR.

ASAP.

Page 1

Item ID: PB67-43001-85

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: D-Pad Assembly, Long

Stop ***NS2***

Start Date: 9/20/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: **21**

Date:

OCT 20 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-85	D
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100 Pick Kit

0.00

100

Packaging Memo

0.00

Packaging

8 NOV 24 2016DAS
24
9-89110 Weld per dwg A/R Aluminum rod Batch: **134826**

Large Fab

110

Large Fab Memo

0.04

Large Fab 1- Assemble and weld as per dwg B67-43001 (QSI004)

2- Grind weld flush only on side of -193

8 NOV 24 2016DAS
24
9-89

130 QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC Memo

0.00

Quality Control

8 11.11.24DAS
9
9-89

Work Order ID 152117

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Page 3

Item ID: PB67-43001-85**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** D-Pad Assembly, Long**Start Date:** 9/20/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 10/19/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1***Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>34554</u>								
	SEND TO TALMAR FOR FOAM AND FABRIC								
	C OF C IS REQUIRED								
180	Receive & Inspect for Damage & Mat'l Certs	0.00							
180									
Packaging	Memo	0.01							
Packaging									
190	QC6- Inspect dimensions to drawing	0.00							
190									
QC	Memo	0.00							
Quality Control									

8 DEC 07 2016DAS
13
9-89SX SP17-01-4③ 17-01-04DAS
9
9-89

Work Order ID 152117

Wednesday, October 19, 2016 3:29:11 PM

152117

Page 4

Item ID: PB67-43001-85 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: D-Pad Assembly, Long
Start Date: 9/20/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: 	0.00					JAN 04 2017		
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210								JAN 09 2017	
QC	Memo	0.03							
Quality Control									

 JAN 04 2017



Picklist Print

Wednesday, October 19, 2016 3:29:11 PM

Page 1

Work Order ID: 152117

152117

Parent Item: PB67-43001-85

PB67-43001-85

Parent Item Name: D-Pad Assembly, Long

Start Date: 9/20/2016

Required Date: 10/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A new issue 08.06.19 EC verified: DD
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-191

Manufactured

No

110

Each

16.0000

1

2

PR67-43001-191

D-Pad Back Plate

Location

Loc Qty

Loc Code

Mezz2

16

138671

1

148044

15

x 7

mf 16-11-23

PB67-43001-193

Manufactured

No

110

Each

27.0000

1

2

PR67-43001-193

D-Pad Base

Location

Loc Qty

Loc Code

Mezz2

27

148045

27

mf 16-11-23

PB67-43001-195

Manufactured

No

100

Each

12.0000

1

2

PR67-43001-195

D-Pad Face

Location

Loc Qty

Loc Code

Mezz2

12

148046

12

mf 16-11-25

PB67-43001-339

Manufactured

No

110

Each

16.0000

1

2

PR67-43001-339

D-Pad Top

Location

Loc Qty

Loc Code

Mezz2

16

138666

3

148047

13

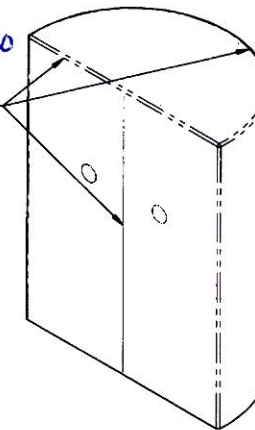
x 5

mf 16-11-25

ITEM	QTY -85	P/N	DESCRIPTION
	X	B67-43001-85	D-PAD ASSEMBLY, LONG
1	1	B67-43001-85W	LONG D-PAD WELDMENT
2	A/R	FOAM	SEE NOTE 1.1
3	A/R	FABRIC	SEE NOTE 1.2
4	A/R	ADHESIVE	SEE NOTE 1.3
5	A/R	THREAD	SEE NOTE 1.4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152117 *MLJ*
16-10-20

1.4 LOCATION OF SEWING SEAM



RELEASED
2014-12-08
W

B67-43001-85 D-PAD ASSEMBLY, LONG

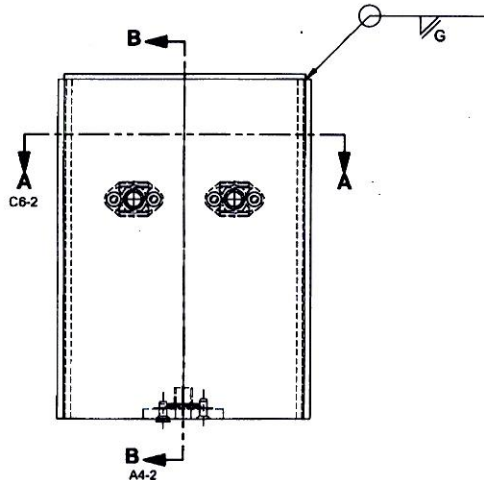
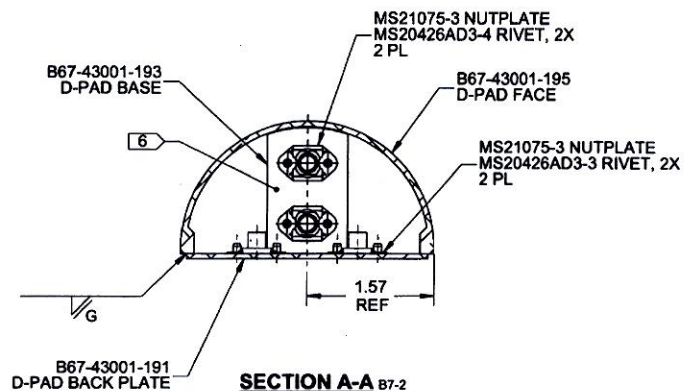
NOTES:

- 1) MATERIAL:
 - 1.1) FOAM: SBR/EPDM/CR BLEND, BLACK, ASTM D1056 2A2, 1/8" THICK, BRITTLENESS TEMP OF -40F, IAW ASTM D 746
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK
REF. TULMAR P/N 1495
 - 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC
 - 1.4) THREAD: NYLON, BLACK, V-T-295 TYPE 2, CLASS A, SIZE F, 8-10 STITCHES PER INCH
REF. TULMAR P/N 2530
- 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
- 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs REF
- 8) NUTPLATES AD HOLES MUST REMAIN FREE OF ADHESIVE AND FABRIC
- 9) DENIER NYLON TO OVERLAP BY 0.25 MIN AND BE BONDED ALL AROUND INNER SIDES OF PLATE

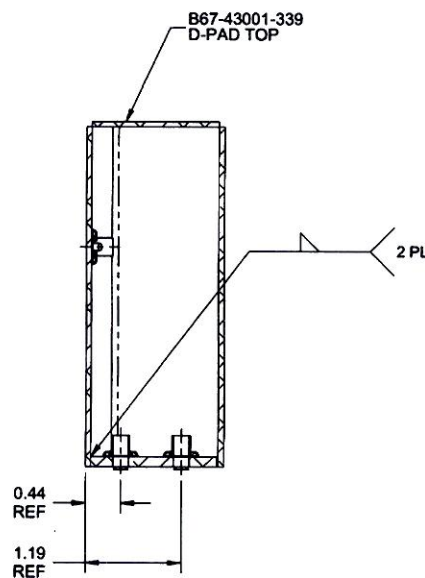
TABLE 1 3

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

D	FOAM AND ADHESIVE SPECS CHANGE TO MATCH SUPPLIER MATERIALS REASON: SEE PAR #14-333	DB	14.07.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC. FOR PREVIOUS REVISIONS, REFER TO SHEET 12 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-85	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	D-PAD ASSEMBLY, LONG	NTS
DATE	14.07.14	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



B67-43001-85W D-PAD WELDMENT, LONG



SECTION B-B B7-2

ITEM	QTY -85W	P/N	DESCRIPTION
	X	B67-43001-85W	LONG D-PAD WELDMENT
1	4	MS20426AD3-3	RIVET
2	4	MS20426AD3-4	RIVET
3	4	MS21075L3	NUT PLATE
4	1	B67-43001-195	D-PAD FACE
5	1	B67-43001-191	D-PAD BACK PLATE
6	1	B67-43001-339	D-PAD TOP
7	1	B67-43001-193	D-PAD BASE

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-85W" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.30 lbs
 - 8) WELDING: PER DART QSI 004

RELEASED
2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-85	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	D-PAD ASSEMBLY, LONG	NTS
DATE	14.07.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34554**

Purchase Order Date 12/7/2016

PO Print Date 12/7/2016

Page Number 1 of 2

Order From :

VC-TUL001

Ship To : DART AEROSPACE LTD

TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 613 632 1282

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	152117	PB67-43001-85 D-PAD ASSEMBLY	1/6/2017		8.00	\$55.00	\$440.00
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Yes
1/6/2017

FOAM AND FABRIC
TULMAR P/N: 8421-102
INCLUDED MARK UPS AT REV.D + MU REV. D + 1
MISSING ON DART DWG. "TRANSFER DIAM 0.19 HOLE FROM WELDMENT TO FABRIC 2PL"

SP/7-01-4.

Line Total: \$440.00

2	152082	PB67-43001-267 PAD ATTACHEMENT	1/6/2017		1.00	\$110.00	\$110.00
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Yes
1/6/2017

FOAM AND FABRIC AS PER DWG PB67-43001-267 REV. C + 1
TULMAR P/N: 8421-108

Line Total: \$110.00

Note:

12/7/2016

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Packing Slip No Page

59199 1

Ship Date

12/23/2016

Bill To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To:

Dart Aerospace

1270 Aberdeen Street
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7
Canada

Order number 34382 Sales order date 12/7/2016 Account number CDART100 Loc H Account manager Francine Bigras

PO number
PO34554

Ship via
Pick-Up

Shipping Terms
FOB HAWKESBURY

Item No. Description	Quantity ordered	UOM	Qty Shipped/Returned	Quantity on back order
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Line 3

Procurement Quality Clauses:
A004 A005 A007 A016 A026 A040
A041 A043 (TSS=5 yrs only)

8421-102	8.00	EA	8.00	
----------	------	----	------	--

D-Pad Assembly, Long

Drawing No: B67-43001-85 + MU

DWG Rev: D+1

Line 1

SF 41067

Lot no.: BATCH0000000012 8.00

SET-UP OMO	1.00	EA	1.00	
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Set-Up Fee

Line 4

8421-108	1.00	EA	1.00	
----------	------	----	------	--

Dart Blade Fold Kit - Pad #9

Drawing No: B67-43001-267+MU

DWG Rev: C+1

Line 2

SF 41068

Lot no.: BATCH0000000009 1.00

Certificate of Conformance

☒ See Certification Enclosed

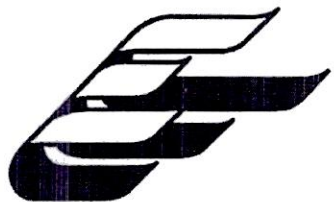
I hereby certify that the items listed hereon have been inspected, and / or tested (as applicable), conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Lorraine LaLiberte

Date:

DEC 23 2016



J. ENNIS FABRICS

June 10, 2015

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Certificate of Conformance

Re: PO 28594-00 for Oxford 7 black

The goods shipped on P/O 28594-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 black is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # 111926200 Manufacture Date: 03/25/15, Lot Number: 444815

Sincerely;

J. Ennis Fabrics Ltd.

S, Nolan

Susan Nolan
Customer Service Specialist

*cl's used to mfg. B67-43001-85+MU
Rev. D+1*

*Sandra Nadeau (cc)
Dec-23/16*

DAS
9
9-89

JUN 19 2015

*1495 # 33
B*



TULMAR**Certificate of Conformance**

Tulmar P/N 1637-002	Description 1/8" X 42" X 72"	Dwg #	Revision	Qty 2
Tulmar PO # 30234-00	Line Item # 01	Supplier Name / Address AM RUBBER & FOAM GASKETS INC 2074 STEELES AVE. EAST, UNITS 1 & 2 BRAMPTON, ON L6T 4Z9		Supplier Packing Slip # 16563

Supplier Declarations:

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods : CANADA		if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

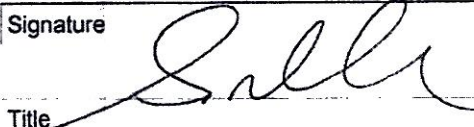
if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

FOAM, SBR/EPDM/CR BLEND, BLACK
ASTM D1056 2A2, 1/8" THK.
SHEET SIZE 42" X 72" +/-0.5"
BRITTLNESS TEMP OF -40 DEGREES F
IAW ASTM D746
QUALITY CLAUSE: GrBT3

DAS
9
9-89

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name SANDRA PULSINELLI	Date (DD-MMM-YYYY) 20-06-2016
Title PRODUCTION	Email sandra@amrubber.ca	Phone # 905-455-1449

1637-002 JUL 05 2016

B# 8 Ae



Form Revision 13 Aug 2012

May 11, 2016

TULMAR SAFETY SYSTEMS
 1123 CAMERON STREET
 HAWKSBURY, ONTARIO
 K6A 2B8

CERTIFICATE OF COMPLIANCE

This is to certify that the item mentioned below, shipped to Tulmar Safety Systems by Cansew Inc. on May 10, 2016, has been produced in accordance with the requirements of Purchase Order no. 30118-00 of the same date:

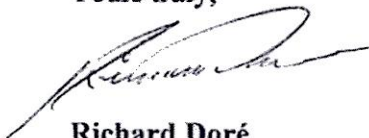
- **NB CBB92 LB;** Cansew Nylon -- Qty 22.50 lbs, Colour: Black
 LOT #: F78828

Description

Thread, Nylon, Twisted, Black, A-A-59826, TY2, CLA, Size F, CBB92, (Supercedes V-T-295)

Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have include, the following substances:	Hexavalent Chromium: Cadmium: Beryllium; Nickel; Mercury; Lead; Asbesotos; Radioactive elements YES NO ●
Country of Origin of Goods: USA		
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shlf-life there is no effect on final product.	These items have limited Shelf-Life YES NO ●
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended – expiration is transferred to the final product.	These items have expiry date YES NO ●

Yours truly,



Richard Doré
 Sales Manager

MONTREAL
 111 Chabanel W. H2N 1C9
 Tel. (514) 382-2801
 1-800-361-7722
 Fax: (514) 385-5530
 E-mail: info@cansew.ca
www.cansew.ca

TORONTO
 28 Apex Rd. M6A 2V2
 (416)782-1122
 1-800-387-8584
 (416)782-8358
info@cansew.ca

WINNIPEG
 1674 Church Ave. R2X 2W9
 (204)942-4264
 1-800-665-0701
 (204)947-9280
info@cansew.ca

CALGARY
 3932-29th St. N.E. T1Y 6B6
 (403)291-4494
 1-800-667-4197
 (403)291-5139
info@cansew.ca

VANCOUVER
 1217 East Georgia St. V6A 2A9
 (604)682-4341
 1-800-580-0737
 (604)682-4196
info@cansew.ca

TSS 2530 B/55





48 Burgess Place
Wayne, NJ 07470

Certificate Of Analysis

12/12/2016

Sales Order Number: 8915

Customer Order Number: 30687

Manufactured for
TULMAR SAFETY SYSTEMS

14172-C6.9A LA4009NOVOC, P/N 7122-001 14172-C6.9A - LA4009NOVOC, UNLINED GALLON CAN

Lot# PNJ-1116-0171 Qty: 54 CANS + PART CAN @ 3# Manufacture Date: 11/15/16 Expiration Date: 11/15/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	14.4000	13.00	15.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	915.0000	800.00	1,500.00	Centipoise
Visual check for dry film color	pass	(CLEAR TO HAZY YELLOW) PASS/FAIL		

14556-S1.9 CAT7020, P/N 7153-002 14556-S1.9 - CAT7020 QUART CANS SQUARE UNLINED

Lot# PNJ-1116-0170 Qty: 11 EA Manufacture Date: 11/16/16 Expiration Date: 5/18/17

Test(s)	Results	Min	Max
	NOT APPLICABLE	NA	NA

14914-C7 DB7020M1, P/N 7153-001 14914-C7 - DB7020M1, GALLON LINED CAN

Lot# PNJ-1116-0172 Qty: 56 CANS + PART CAN @ 4# Manufacture Date: 11/21/16 Expiration Date: 5/23/17

Test(s)	Results	Min	Max	
% Solids @275F for 30 minutes	23.0000	21.00	24.00	Percent
Brookfield,RVT,#3 Spindle,20RPM,78F	695.0000	450.00	1,250.00	Centipoise

"The material supplied conforms to all applicable engineering drawing, specifications and PO requirements."

Dan Constantino

Daniel Constantino

Quality Assurance Mgr/ISO Coordinator

Country of Origin: USA

DEC 19 2016



7122-001
B#8